

Date: Friday, 3/16/2007 1:12:59 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	206/OH-58 SADDLE, INBOARD, RIGHT SIDE		
Job Number	31251					
Estimate Number	10834					
P.O. Number	N/A			Part Number	D29332	
This Issue	3/16/2007			Drawing Number	D2933 UNDER REVIEW C	
Prsh Rev.	NC			Project Number	N/A CB 07.03/16	
First Issue	3/16/2007	Type	MACHINED PARTS	Drawing Revision	B C	
Previous Run	30487			Material	N/A	
Written By				Due Date	3/30/2007	
Checked & Approved By	<u>07.03.16</u>			Qty:	8	
Comment	Est: B 06-06-26 New DWG rev (mpp 2069) EC			Um:	Each	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101001	7075-T7351 2X6X6.25	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: <u>25345</u>	<u>MS 07/03/22 8</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. <u>En 07/03/24</u> 1-Inspect part number and batch number are programmed correctly. <u>SA 07.03.24</u> 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr	<u>EP 07/03/25</u>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<u>En 07/03/25</u>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<u>En 07/03/25</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/03/2020  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 3/16/2007 1:13:00 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 31251

Part Number: D29332

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 07.03.25

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MJ

07-03-25(8)

7.0 POWDER COATING POWDER COATING



M 103706

(8X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h

07/03/26

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/03/27(8)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/03/27(8)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/28

Job Completion



U 07/03/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:			
Description: 206 Saddle, Inboard, Right side				Part Number: D2933-2			
Inspection Dwg: D2933 Rev. B				Page 1 of 1			

CS 07.03.16

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.126	0.123	0.122	0.122		
B	0.100	0.140		0.121	0.122	0.123	0.121		
C	0.100	0.140		0.136	0.134	0.130	0.128		
D	0.210	0.230		0.221	0.221	0.223	0.220		
E	1.245	1.255		1.247	1.246	1.246	1.253		
F	1.245	1.255		1.247	1.246	1.246	1.250		
G	2.495	2.505		2.500	2.501	2.497	2.501		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.573	1.575	1.575	1.577		
J	2.495	2.505		2.499	2.500	2.499	2.496		
K	0.257	0.262	DT8683	0.251	0.259	0.257	0.259		
L	0.312	0.317	DT8686	0.315	0.315	0.315	0.315		
M	0.235	0.240		0.240	0.240	0.239	0.239		
N	0.100	0.140		?	?	?	?		
O	0.540	0.560		0.545	0.545	0.541	0.541		
P	0.490	0.510		0.498	0.495	0.496	0.496		
Q	3.715	3.725		3.719	3.718	3.720	3.720		
R	2.470	2.510		2.500	2.494	2.499	2.499		
S	0.240	0.270		0.255	0.253	0.254	0.254		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.627	1.630	1.630		
V	1.362	1.372		1.366	1.364	1.364	1.364		
W	0.316	0.321	DT8690	0.320	0.320	0.320	0.320		
X	1.125	1.145		1.134	1.134	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	✓	✓	✓	✓		
Z	5.990	6.010		6.004	6.002	6.001	6.002		
AA	0.015	0.035		0.015	0.025	0.025	0.025		
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by:	SP	Audited by:	SA
Date:	07/03/24	Date:	07.03.25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#



DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. B/C		Page 1 of 1

CB 07.03.16

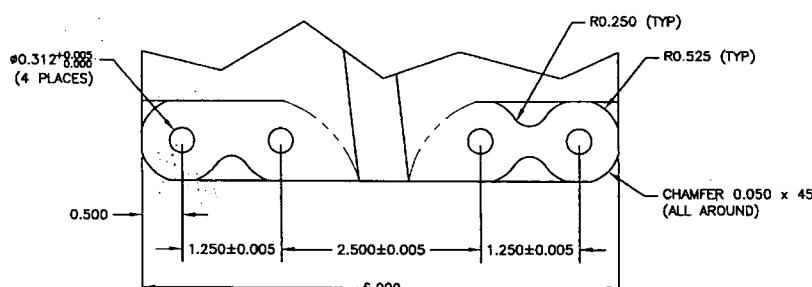
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.123	0.123	0.123	0.122		
B	0.100	0.140		0.120	0.121	0.123	0.123		
C	0.100	0.140		0.137	0.134	0.134	0.134		
D	0.210	0.230		0.219	0.220	0.221	0.222		
E	1.245	1.255		1.245	1.247	1.248	1.249		
F	1.245	1.255		1.249	1.247	1.248	1.249		
G	2.495	2.505		2.497	2.500	2.500	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.573	1.574	1.576	1.576		
J	2.495	2.505		2.499	2.499	2.497	2.499		
K	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
L	0.312	0.317	DT8686	0.315	0.315	0.315	0.315		
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140		?	?	?	?		
O	0.540	0.560		0.542	0.542	0.540	0.541		
P	0.490	0.510		0.497	0.498	0.495	0.495		
Q	3.715	3.725		3.719	3.718	3.719	3.719		
R	2.470	2.510		2.495	2.498	2.499	2.490		
S	0.240	0.270		0.253	0.254	0.254	0.254		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.627	1.627	1.627		
V	1.362	1.372		1.364	1.368	1.367	1.364		
W	0.316	0.321	DT8690	0.320	0.320	0.320	0.320		
X	1.125	1.145		1.132	1.134	1.135	1.137		
Y	1.565	1.585	DT8695 A/B	—	—	—	—		
Z	5.990	6.010		6.006	6.002	6.001	6.001		
AA	0.095	0.095		0.025	0.025	0.025	0.025		
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by:	CR	Audited by:	SA
Date:	07.03.25	Date:	07.03.25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF FF	#

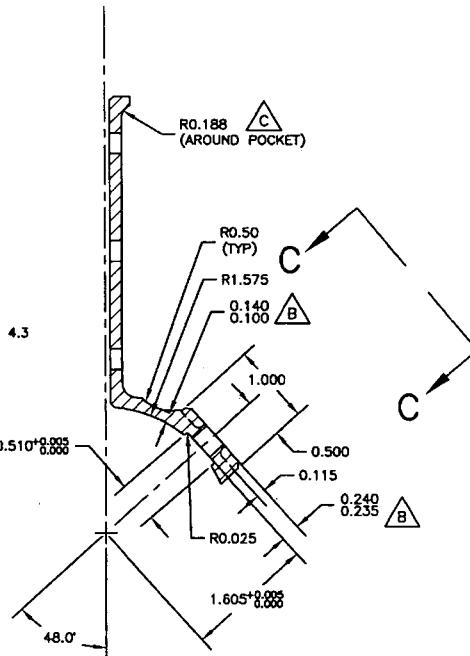


VIEW C-C

**D2933-1 LH SADDLE (SHOWN)**  
**D2933-2 RH SADDLE (OPPOSITE)**

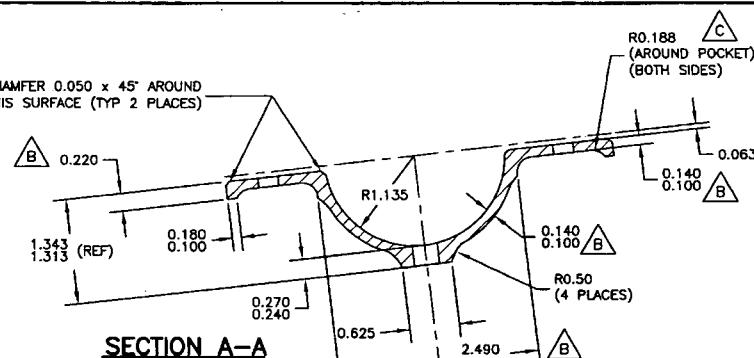
**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QO-A-250/12)  
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

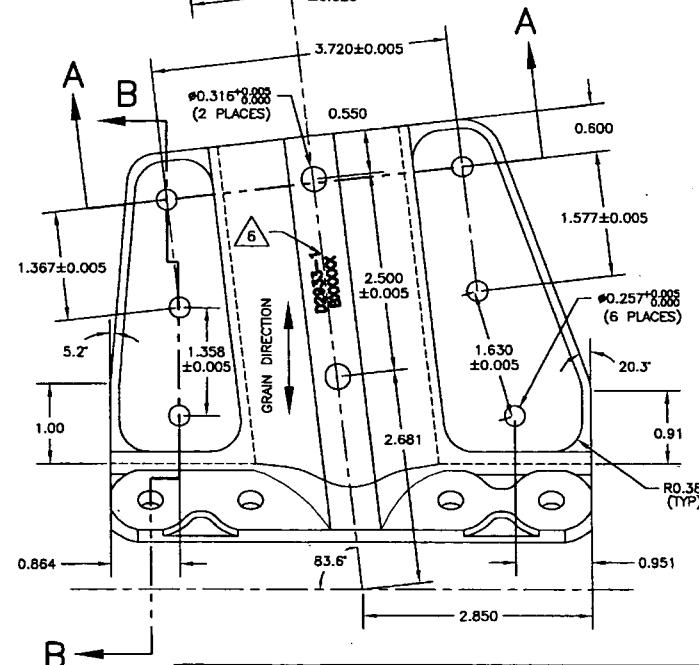


SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED H
DRAWING NO.	D2933	REV. C
DATE	06.11.09	SHEET 1 OF 1
TITLE	SADDLE INSIDE	SCALE 2:3

RELEASER  
07.02.12

NO.  
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